

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016275**Date Inspected:** 01-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Guo Yan Fei, Chen Shi Gang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 04, DECK PANEL REPAIR**13BW-DP3136-001**

During random in process inspection this QA inspector observed that ZPMC personnel were performing repair welding on the Partial Joint Penetration (PJP) weld joints of deck panel 13BW-DP3136-001. Welder is identified as 203805. ZPMC CWI is identified as Mr. Guo Yan Fei. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-FCM-Repair. The repair area details are as follows.

Weld: 002; Y location: 50, 1150

Weld: 006; Y location: 3550

Weld: 007; Y location: 50

Weld: 008; Y location: 50, 2350

Weld: 009; Y location: 50, 3550, 4750

Weld: 010; Y location: 4150

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Weld: 171; Y location: 4750

Weld: 173; Y location: 50

Weld: 178; Y location: 2950

Weld: 179; Y location: 50

13BE-DP3090-001

During random in process inspection this QA inspector observed that ZPMC personnel were performing repair welding on the Partial Joint Penetration (PJP) weld joints of deck panel 13BE-DP3090-001. Welder is identified as 062265. ZPMC QC is identified as Mr. Zhang Hai Tao. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-FCM-Repair. The repair area details are as follows.

Weld: 002; Y location: 50, 1250

Weld: 003; Y location: 1850

Weld: 004; Y location: 4050, 4550

Weld: 005; Y location: 50

Weld: 007; Y location: 650, 1850

Weld: 008; Y location: 50, 1850

Weld: 009; Y location: 1250

Weld: 010; Y location: 1850, 3050, 4050

Weld: 171; Y location: 1850

Weld: 172; Y location: 50

Weld: 173; Y location: 2450

Weld: 178; Y location: 650, 1250

Weld: 180; Y location: 50, 1850

Deck Panel Repair

This QA inspector observed that ZPMC NDT personnel was performing Magnetic Particle Testing (MT) on the repair locations of weld joint of deck panel 13BE-DP3088-001.

BAY 09, U-rib Internal Cover Plate

FCAW welding of weld joint 316 located on DP3172-001.

Welder is identified as 201788. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 326 located on DP3172-001.

Welder is identified as 201788. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 383 located on DP3173-001.

Welder is identified as 059443. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

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FCAW welding of weld joint 381 located on DP3173-001.

Welder is identified as 059443. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 364 located on DP3173-001.

Welder is identified as 059378. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 362 located on DP3173-001.

Welder is identified as 059378. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
